

Work Order ID 115341

March-26-14 10:19:25 AM

115341

Page 1

Item ID: D3536-25

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Gasket Center

Start Date: 3/26/14 Start Qty: 12.00

12

Cust Item ID:

Required Date: 4/09/14 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLS Date: 14-03-26 Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3536	Rev A
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100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

13 0 Jm14-04-6

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

13 0 Jm14-04-6

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS

27

9/89

14/4/7

13

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Page 2

Item ID: D3536-25 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Gasket Center
 Start Date: 3/26/14 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 4/09/14 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>FP-001</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

813 f 81 10/04/07

MLJ 14-04-09

(1404-07)

Picklist Print

March-26-14 10:19:28 AM

Page 1

Work Order ID: 115341

115341

Parent Item: D3536-25

D3536-25

Parent Item Name: Gasket Center

Start Date: 3/26/14

Required Date: 4/09/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MNEO60S.063

Purchased

No

100

sf

1,120.100

0.5956

8

MNEO60S 063

**

Jm14-04-6

NEOPRENE SHEET 0.063

Location

Loc Qty

Loc Code

MAT052

1120.1

M126546

27.1

M128266

293

M128339

800

128266

DART AEROSPACE LTD		Work Order:	115341
Description: Gasket		Part Number:	D3536-25
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.80	+/-0.030	21.80"	✓		T	Jkm07
16.35	+/-0.030	16.35"	✓		T	
10.90	+/-0.030	10.90"	✓		V	Jkm08
5.45	+/-0.030	5.45"	✓		V	Jkm05
6.00	+/-0.030	6.00"	✓		V	
6.75	+/-0.030	6.75"	✓		V	
12.75	+/-0.030	12.75"	✓		T	
1.89	+/-0.030	1.89"	✓		V	
0.30	+/-0.030	0.30"	✓		V	
0.30	+/-0.030	0.30"	✓		V	
Ø0.19	+0.005/-0.001	Ø0.19"	✓		V	

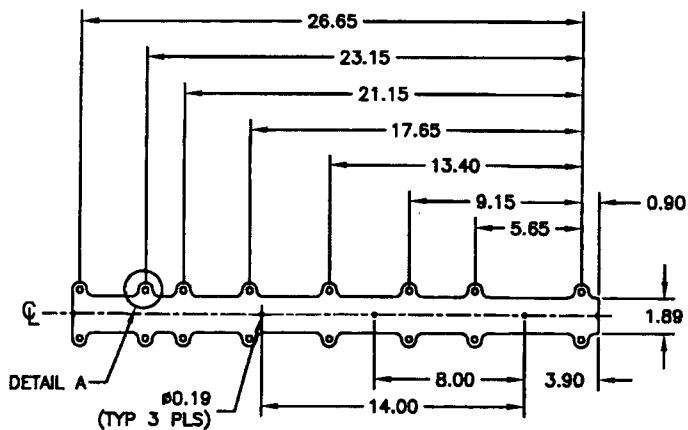
Measured by: Jm	Audited by: DAS 27	Prototype Approval: N/A
Date: 14-04-6	Date: 14/4/7	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM	E

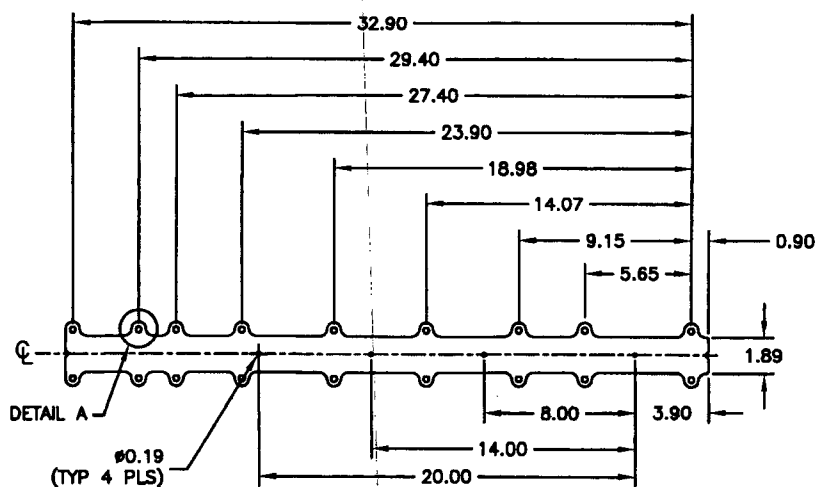


RELEASED
09-02-12-11

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	CB	PORT HADLOCK, WA	
CHECKED PH	APPROVED H	DRAWING NO. D3536	REV. A
DATE 06.10.25	TITLE GASKET	SHEET 1 OF 6	
A	06.10.25	NEW ISSUE	
		SCALE 1:10	



D3536-11 GASKET



D3536-13 GASKET

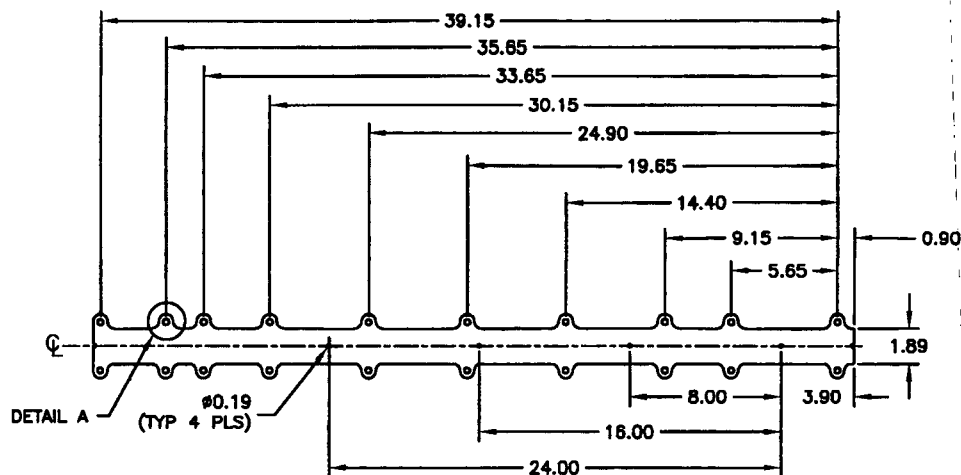
00123

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

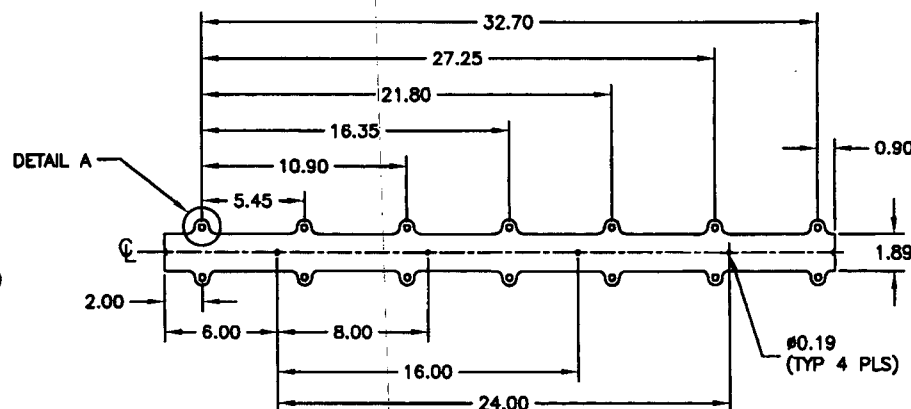


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DATE 06.10.25	TITLE GASKET	SCALE 1:10	

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D3536-15 GASKET



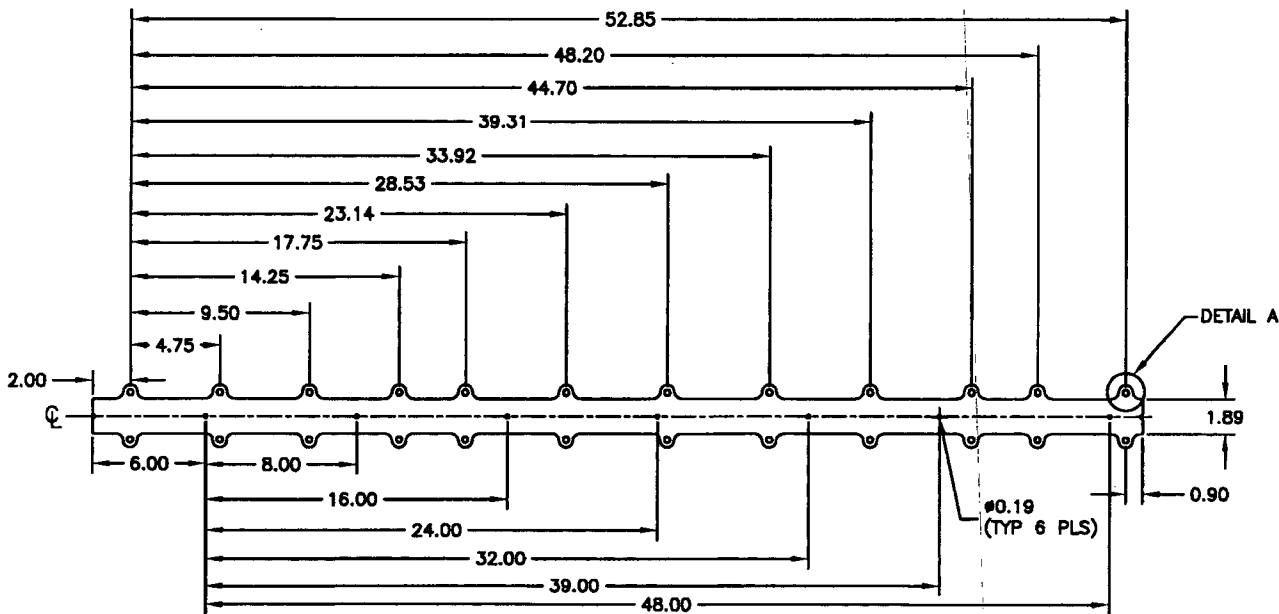
D3536-21 GASKET

NOTES

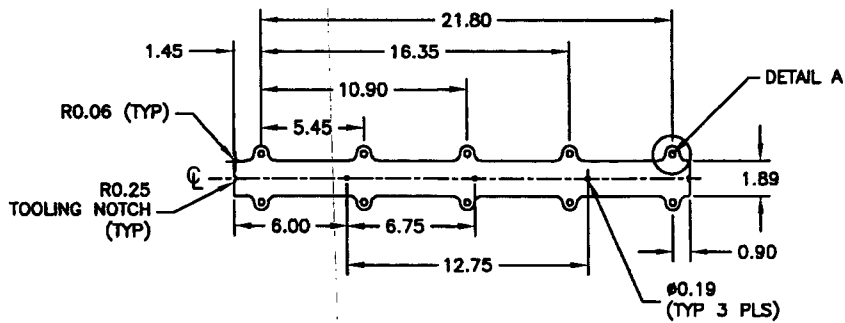
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
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DATE 06.10.25	TITLE GASKET	SCALE 1:10	



D3536-23 GASKET



D3536-25 GASKET

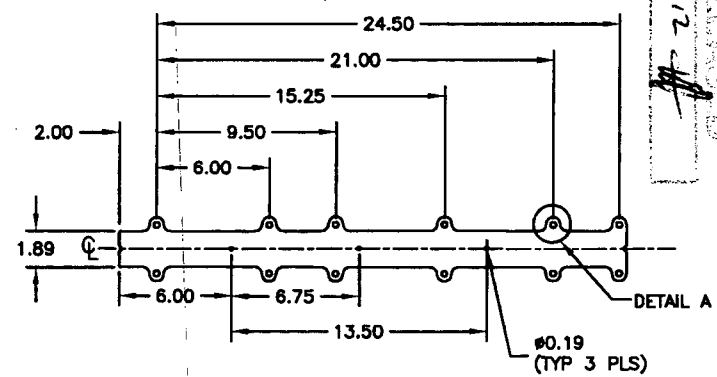
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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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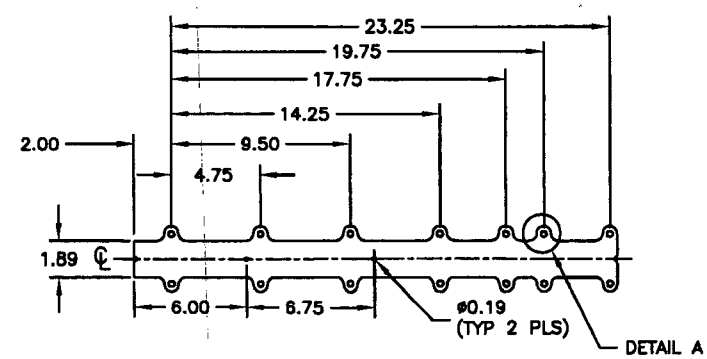


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DATE	06.10.25	TITLE	GASKET	REV. A
		DRAWING NO.	D3536	SHEET 4 OF 6
		SCALE	1:10	

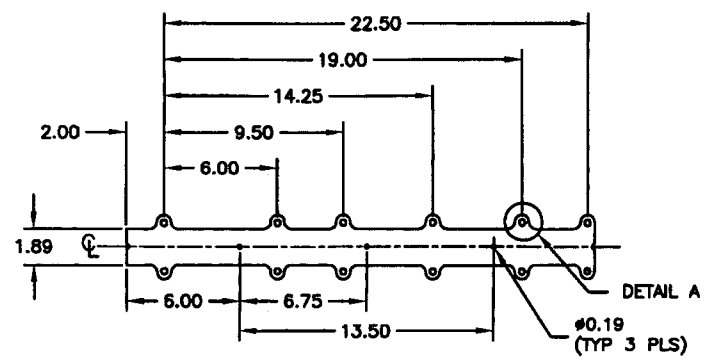
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02.02.12



D3536-33 GASKET



D3536-35 GASKET



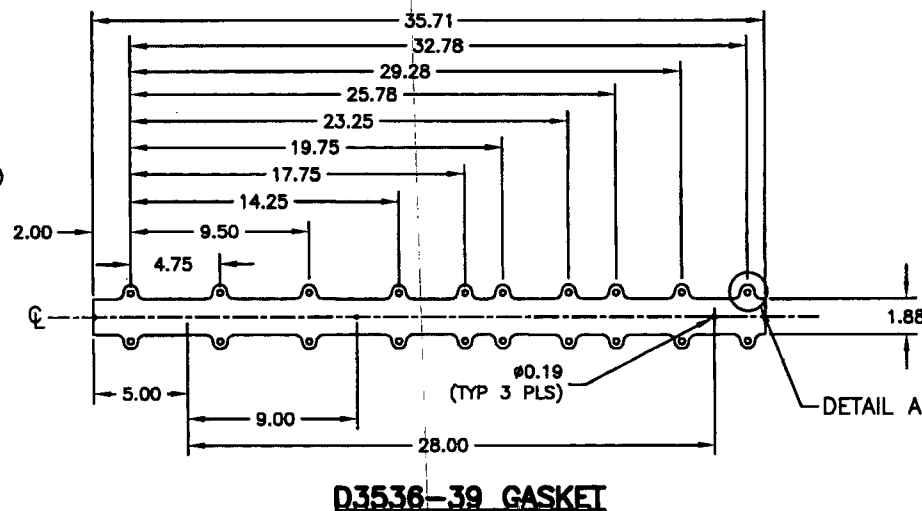
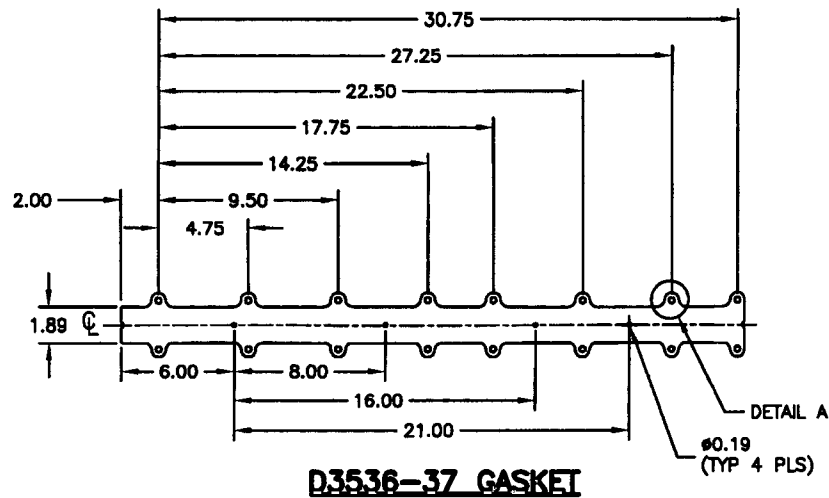
D3536-31 GASKET

- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 5 OF 6
		SCALE	1:10	

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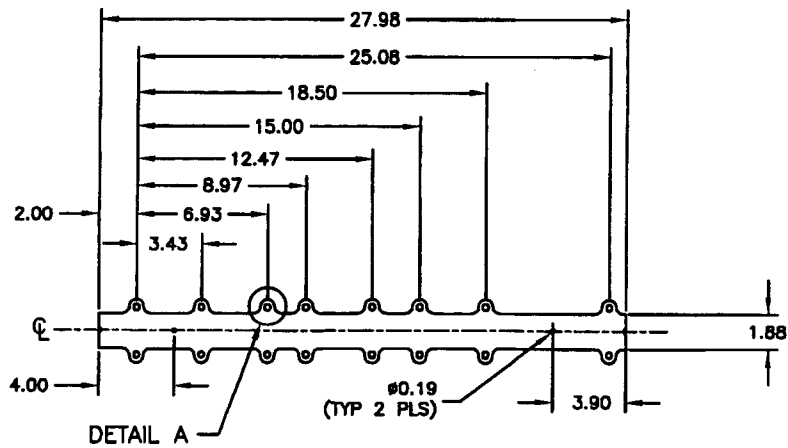
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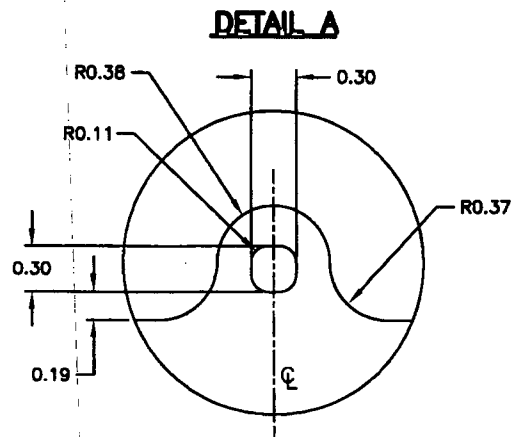


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		TITLE	GASKET	SHEET 6 OF 6
				SCALE 1:10

070612 CB



D3536-41 GASKET



NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
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